

# Work Order ID 57745

April 14, 2010 11:36:49 AM



Page 1

Item ID: D3447-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Swing Arm

Start Date: 14/04/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*14*

Date:

*10-4-14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3447

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.500" x 1.500" x 8.400" long

*ref 10.4.17*

*6*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA544 and Dwg B67-43001 ☐ Identify as D3447-9Dwg  
Rev *A* Folio Rev *A/A* ☐ Deburr

*ref 10.4.17*

*6*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*ref 10.4.17*

*6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	11							

NOTE: Date & initial all entries

# Work Order ID 57745

April 14, 2010 11:36:49 AM



Page 2

Item ID: D3447-9	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Swing Arm					
Start Date: 14/04/2010	Start Qty: 6.00		Cust Item ID:		
Required Date: 22/04/2010	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00							
			DT 10/04/18			6	Ø		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							
			HA 10/04/19			V6	Ø		
150  Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 M18144 Memo	0.00  0.00							
			BR 10-9-23.			6	Ø		
	Mask inside holes as per Dwg D3447 prior to painting								
	TIME: 110								
	320° FINISH TIME: 1:40.								
	OVEN TEMPERATURE:								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 57745**

April 14, 2010 11:36:49 AM



Page 3

Item ID: D3447-9

Accept



Setup Start



Revision ID: -

Stop



Item Name: Swing Arm

Start Date: 14/04/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

mf 10 09 24 (6)

170

Identify as per dwg &amp; Stock Location: 442

0.00



Packaging

Memo

0.00

Packaging

Co 10/09/27 (E)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/27 (E)  
mf  
10-9-24

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April 14, 2010 11:36:54 AM

Page 1

Work Order ID: 57745

Parent Item: D3447-9

Parent Item Name: Swing Arm

Comments: IPP A 05.08.26 New issue KJ/JLM

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M7075T6B1.500X1.500		Purchased	No			100	f	12.0000	4.4211			
7075 T6 BAR 1.500 x 1.500												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT08

12

111485

12

APR 10.4.17

4.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	57745
<b>Description:</b> Swing Arm		<b>Part Number:</b>	D3447-9
<b>Inspection Dwg:</b> D3447	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.02	+/-0.030	8.018	/			
7.075	+/-0.005	7.075	/			
R0.38	+/-0.030	R.38	/			
Ø0.375	+0.006/-0.001	.376	/			
0.75	+/-0.030	.748	/			
0.375	+/-0.005	.376	/			
0.470	+/-0.005	.470	/			
1.100	+/-0.010	1.106	/			
0.71	+/-0.030	.706	/			
0.178	+/-0.010	.176	/			
1.825	+/-0.010	1.820	/			
2.375	+/-0.010	2.375	/			
R0.25	+/-0.030	R.25	/			
R0.13	+/-0.030	R.13	/			
3.700	+/-0.010	3.700	/			
0.25	+/-0.030	.250	/			

<b>Measured by:</b> <i>[Signature]</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10.4.17	<b>Date:</b> 10/04/18	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

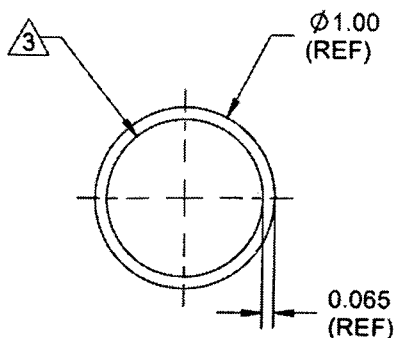
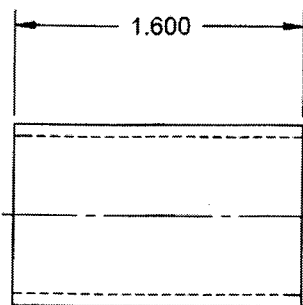
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



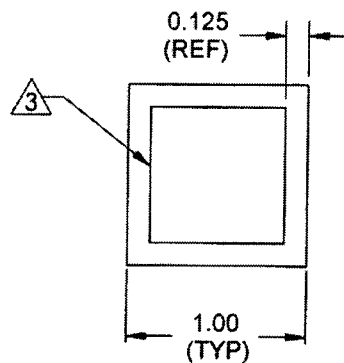
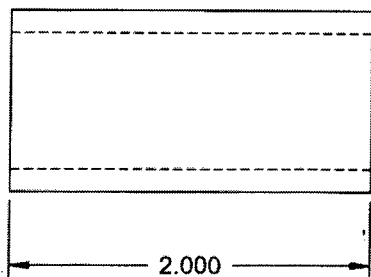
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3447</b>	REV. A SHEET 1 OF 4
DATE <b>05.07.19</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1
A	05.07.19	NEW ISSUE	

RELEASED  
05/08/18



#### **D3447-1 ROUND SPACER**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)



SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 57745  
*[Signature]* 10-4-14

#### **D3447-3 SQUARE SPACER**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.000W.125)

#### **NOTES:**

- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK INSIDE OF TUBING BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

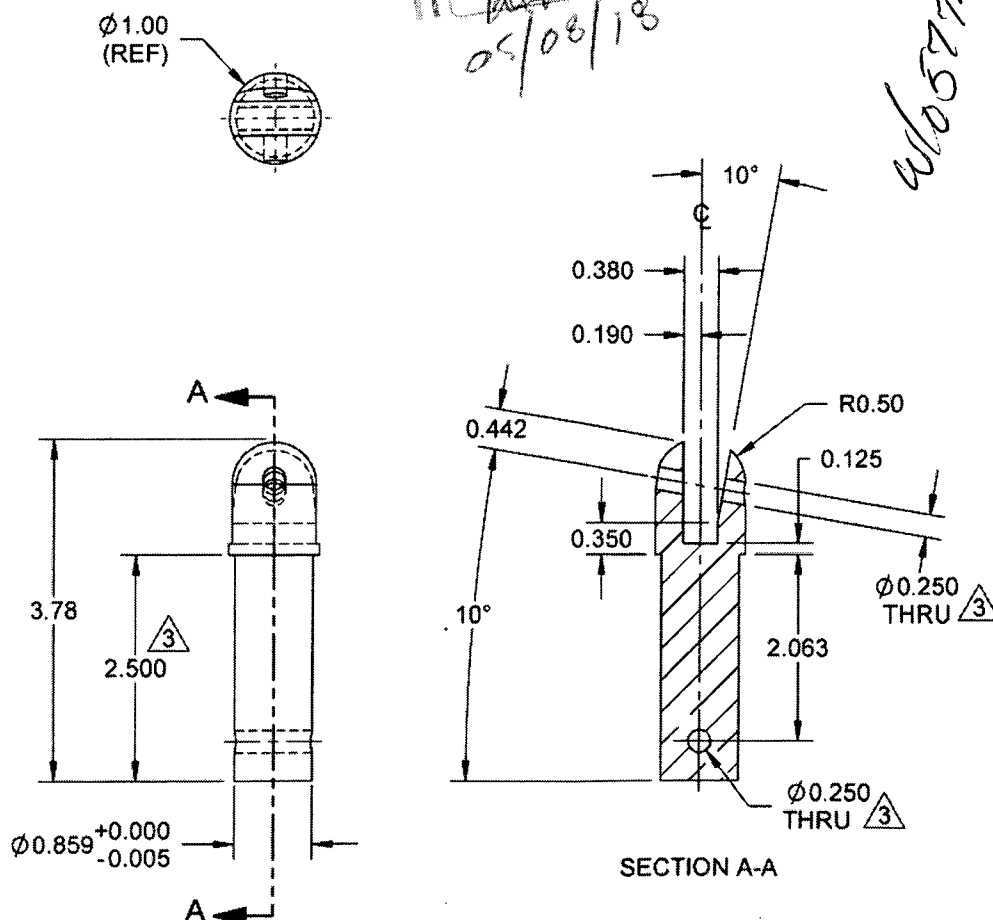
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3447</b>	REV. A SHEET 2 OF 4
DATE <b>05.07.19</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:2



### **D3447-5 CLEVIS**

**SUPERSEDES PREMIER P/N B67-43001-99**

#### **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

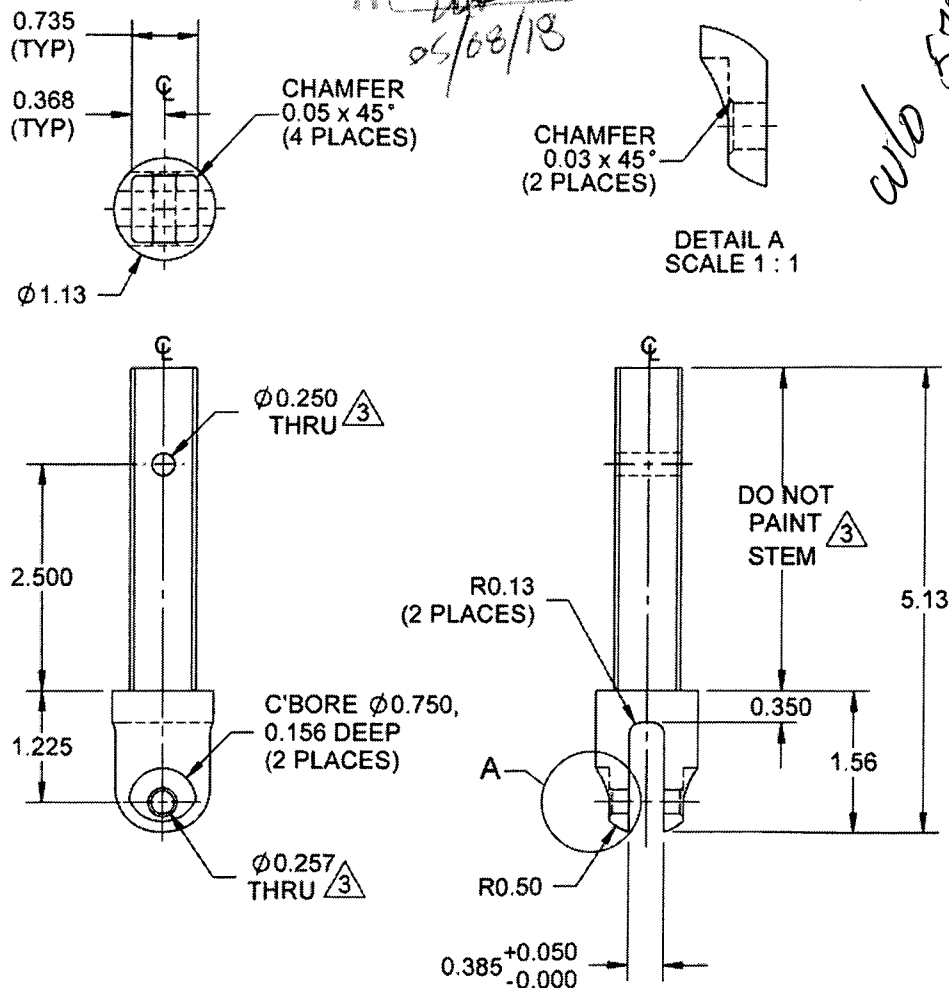
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3447</b>	REV. A SHEET 3 OF 4
DATE <b>05.07.19</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:2

**D3447-7 CLEVIS****SUPERCEDES PREMIER P/N B67-43001-145/-345****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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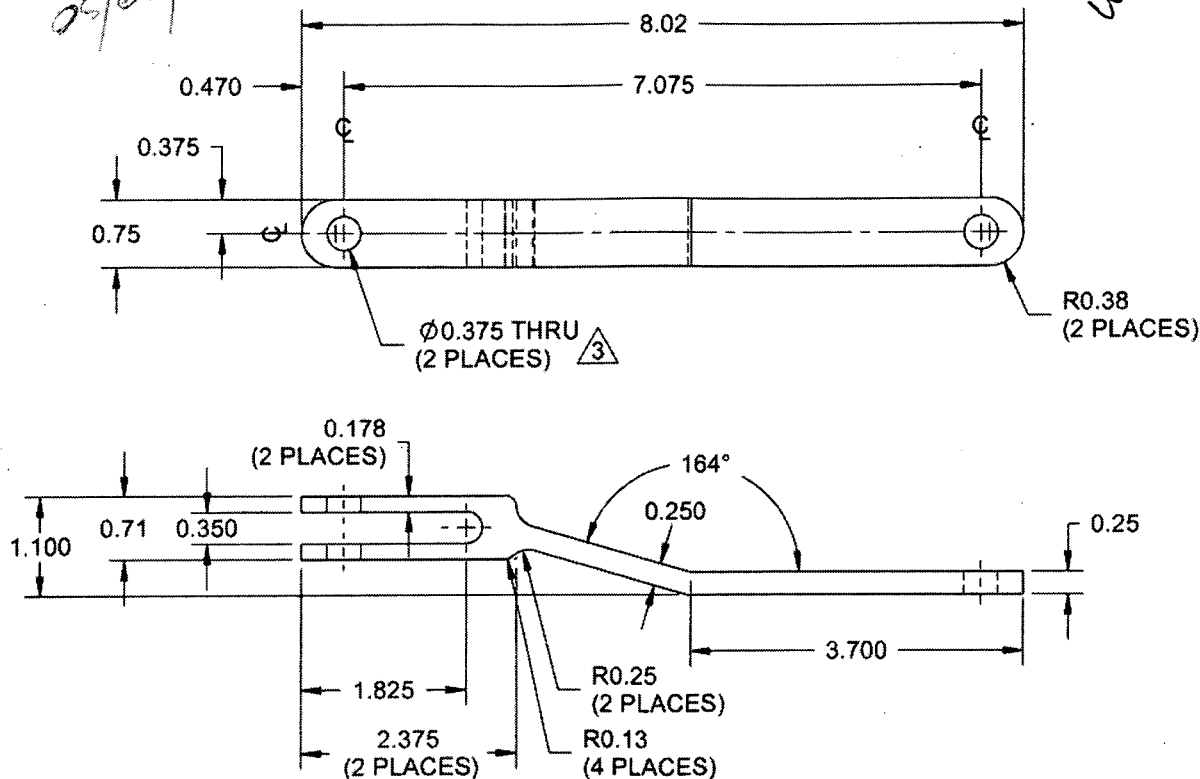




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DATE 05.07.19	TITLE BLADE FOLD KIT PARTS		SCALE 1:2

RELEASED  
*[Signature]*  
05/08/18

*w/b 57745*



**D3447-9 SWING ARM**  
**SUPERSEDES PREMIER P/N B67-43001-263**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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